
















Date: Monday, 27/10/2008 2:16:22 PM
 User: Julie Dawson

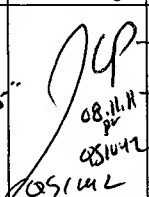
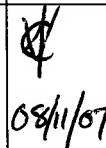
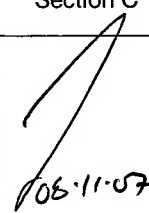
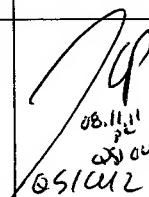
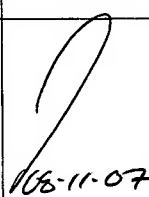
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 42979	Part Number	: D34903
Estimate Number	: 12323	Drawing Number	: D3490 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 27/10/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 10/11/2008 Qty: 60 Um: Each
Previous Run	: 42186		
Written By	:		
Checked & Approved By	: <u>JUL 08.10.28</u>		
Comment	: Est Rev:A New Issue 06-03-03 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0750	6061-T6 Round Bar .750"	
			
Comment: Qty.: 0.2793 f(s)/Unit Total: 16.7580 f(s) 6061-T6 .750" ROUND BAR (M6061T6R0750) Batch: <u>M109807</u> <u>08/11/07</u>  <u>60 pcs</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA629 & DWG D3490 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>08/11/07</u>  <u>60 pcs</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>08/11/07</u>  <u>60 pcs</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>08/11/07</u>  <u>60</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>BARCLAY</u> <u>08/11/10</u> <u>Bo</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3490-3 PAR #: N/A Fault Category: Prod. Mactb. NCR: Yes No DQA: JA Date: 08.11.11
 (0350-636-011/012) Resolution: Accepted Disposition: Use as is QA: N/C Closed: JA Date: 08/11/20

NCR: <u>42979</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.11.07	2.0	Qty 4 parts are too short by 0.001" → 0.0015" starting origin was off by 0.0015" R.C: operator error	 08.11.11 08/11/11	parts acceptable. Have employee inspect in accordance with QSP019 or every 15-30 parts.	 08/11/07	 08.11.07	 08.11.11 08/11/11	 08.11.07

NOTE: Date & initial all entries

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User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 42979

Part Number: D34903

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF 08-11-10

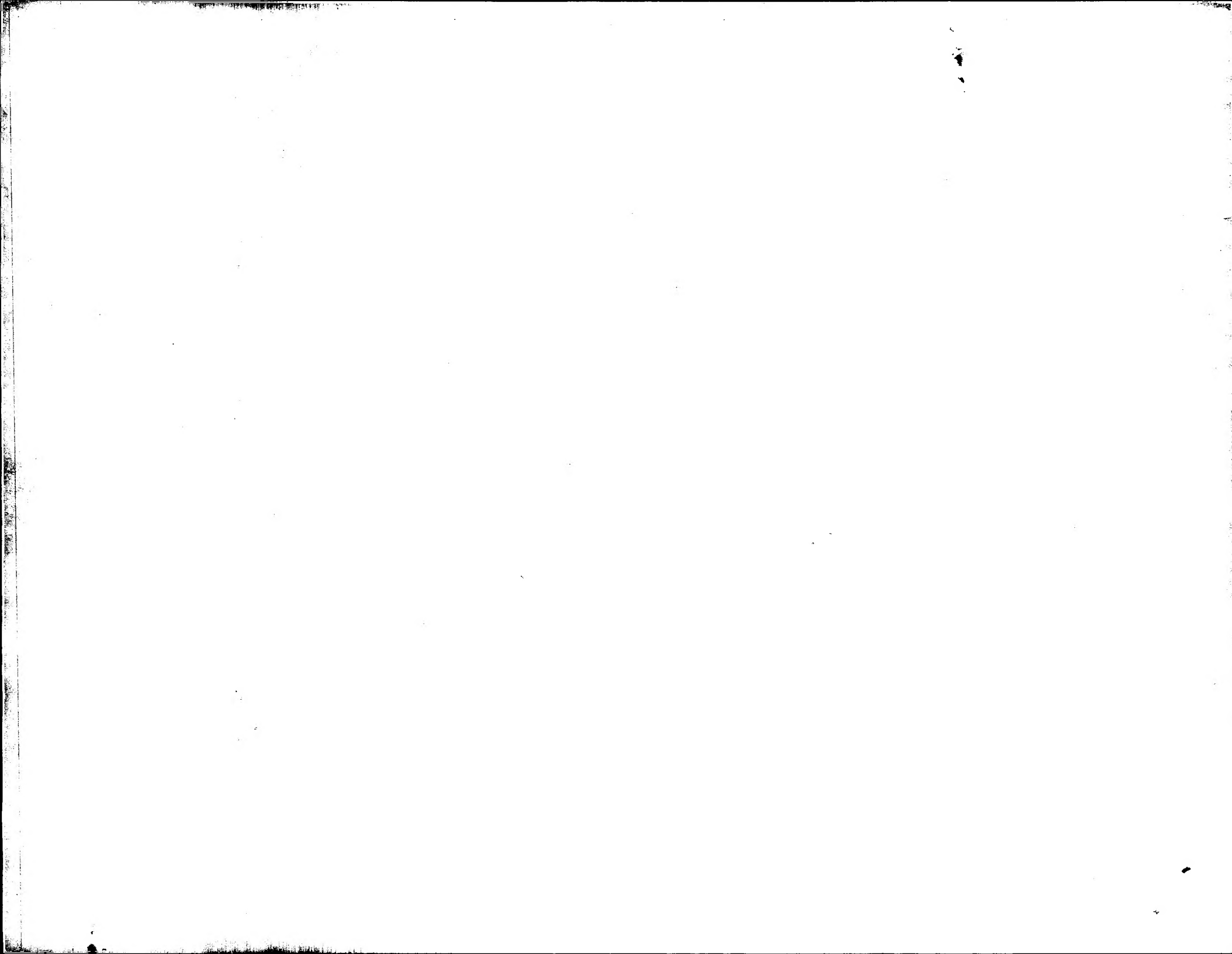
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

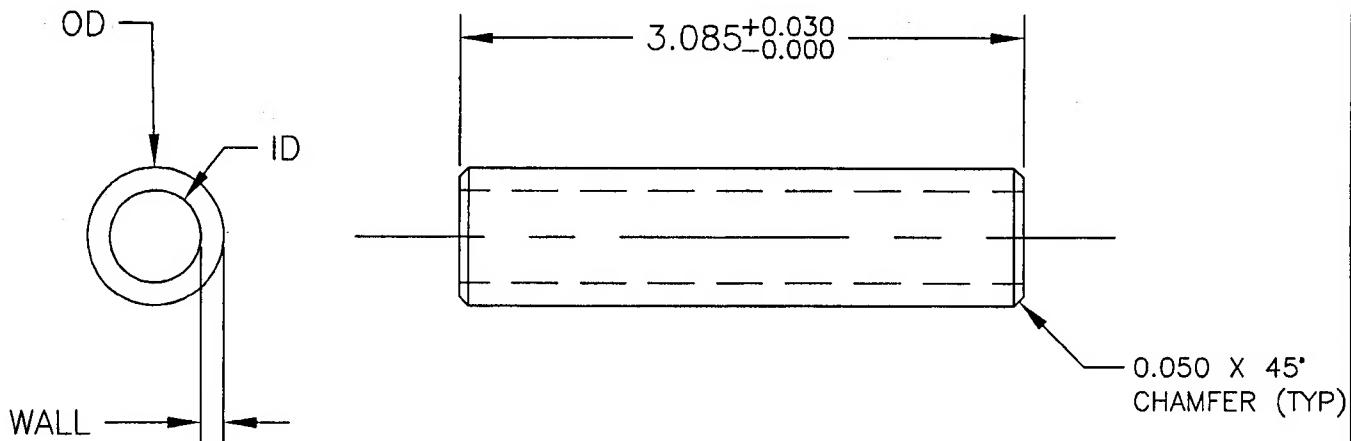
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 42979

RELEASED
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